



Dart Aerospace Ltd.
1270 Aberdeen St
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K6A 1K7
Canada

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SPH

5

D2563

Job Sheet 208025



Part No: D2563

Job Qty: 5 pcs

Part Name: Step Weldment Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 3/9/20

Job Tracking No:

Due Date: 4/8/20

Created By: Jennifer Renwick

Type: Stock

Description:

Note: DWG REV C IPP Rev:G 02.07.31 Re-format Location RF

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Lead Time	Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier			
100	Large Fab - Welded Assy-1	8 pcs			0.00	20.00	Large Fab - 1			
							Large Fab - 10			
							Large Fab - 2			
							Large Fab - 3			
							Large Fab - 4			
							Large Fab - 5			
							Large Fab - 6			
							Large Fab - 7			
							Large Fab - 8			
							Large Fab - 9			
							Large Fab - 11 (Various)			
							Large Fab - 12			
110	QC 9	8 pcs			0.00	0.00	QC 9 - 10			
							QC 9 - 18			
							QC 9 - 24			
							QC 9 - 43			
							QC 9 - 50			
							QC 9 - 9			
120	QC 5	8 pcs			0.00	0.00	QC 5 - 10			
							QC 5 - 12			
							QC 5 - 17			
							QC 5 - 18			
							QC 5 - 19			
							QC 5 - 22			
							QC 5 - 24			
							QC 5 - 3			
							QC 5 - 43			
							QC 5 - 49			
							QC 5 - 51			
							QC 5 - 58			
							QC 5 - 68			

ART

EROSPACE

Order No: S266817



2563

: 208025

No/Batch: S266817

Dart Aerospace Ltd.

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Hawkesbury, ON K64 1K7

CANADA

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Container No: S266817



Part: D2563

Job No: 208025

Serial No/Batch: S266817

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 03/26/20

Plex 3/9/20 2:28 PM Dart.Renwick.Jennifer

				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
				QC 5 - 81	
130	Handfinish - 1-1 Chemical-B4B	8 pcs	0.00 2.15	Handfinish - 1 - 1 - B4B	BEB20-04-15
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
140	QC 7	8 pcs	0.00 0.00	QC 7 - 10	DAS 24 9-89
				QC 7 - 13	
				QC 7 - 14	
				QC 7 - 15	
				QC 7 - 17	
				QC 7 - 18	
				QC 7 - 19	
				QC 7 - 2	
				QC 7 - 28	
				QC 7 - 3	
				QC 7 - 30	
				QC 7 - 34	
				QC 7 - 36	
				QC 7 - 37	
				QC 7 - 41	
				QC 7 - 47	
				QC 7 - 48	
				QC 7 - 51	
				QC 7 - 58	
				QC 7 - 59	
				QC 7 - 60	
				QC 7 - 9	
				QC 7 - 68	
				QC 7 - 50	
				QC 7 - 67	
				QC 7 - 40	
				QC 7 - 24	
				QC 7 - 43	
				QC 7 - 61	
				QC 7 - 81	
				QC 7 - 76	

			QC 7 - 79	
			QC 7 - 83	
			QC 7 - 82	
150 Large Fab - Welded Assy-2-B4B	8 pcs	0.00 4.00	Large Fab - 1 - B4B	JLH
			Large Fab - 10 - B4B	
			Large Fab - 2 - B4B	
			Large Fab - 3 - B4B	
			Large Fab - 4 - B4B	
			Large Fab - 5 - B4B	
			Large Fab - 6 - B4B	
			Large Fab - 7 - B4B	
			Large Fab - 8 - B4B	
			Large Fab - 9 - B4B	
			Large Fab - 11 - B4B (Various)	
			Large Fab - 12 - B4B	
160 QC 10	8 pcs	0.00 0.00	QC 10 - 10	
			QC 10 - 18	
			QC 10 - 24	DAS
			QC 10 - 43	24
			QC 10 - 50	9-89
			QC 10 - 58	
			QC 10 - 9	
			QC 10 - 68	
170 QC 5	8 pcs	0.00 0.00	QC 5 - 10	
			QC 5 - 12	
			QC 5 - 17	
			QC 5 - 18	
			QC 5 - 19	
			QC 5 - 22	
			QC 5 - 24	
			QC 5 - 3	DAS
			QC 5 - 43	24
			QC 5 - 49	9-89
			QC 5 - 51	
			QC 5 - 58	
			QC 5 - 68	
			QC 5 - 9	
			QC 5 - 50	
			QC 5 - 30	
			QC 5 - 40	
			QC 5 - 61	
			QC 5 - 81	
175 Handfinish - 2-1 Pressure-B4B	8 pcs	0.00 2.15	Handfinish - 2 - 1 - B4B	BFB 20-04-12
			Handfinish - 2 - 2 - B4B	
			Handfinish - 2 - 3 - B4B	
			Handfinish - 2 - 4 - B4B	
180 Powdercoat - 1 White GI(A)-B4B	8 pcs	0.00 1.33	Powdercoat - 1 - B4B	
			Powdercoat - 2 - B4B	
			Powdercoat - 3 - B4B	20-04-20
			Powdercoat - 4 - B4B	20-04-20
190 Handfinish - 3-1- WingWalk-B4B	8 pcs	0.00 2.15	Handfinish - 3 - 1 - B4B	JLH 20-04-20
			Handfinish - 3 - 2 - B4B	
			Handfinish - 3 - 3 - B4B	
			Handfinish - 3 - 4 - B4B	
			Handfinish - 3 - 5 - B4B	
200 QC 3	8 pcs	0.00 0.00	QC 3 - 10	
			QC 3 - 13	
			QC 3 - 15	

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			QC 3 - 17	
			QC 3 - 18	
			QC 3 - 2	
			QC 3 - 28	
			QC 3 - 3	
			QC 3 - 30	
			QC 3 - 34	
			QC 3 - 36	
			QC 3 - 41	
			QC 3 - 51	
			QC 3 - 58	
			QC 3 - 59	
			QC 3 - 68	
			QC 3 - 9	
			QC 3 - 40	
			QC 3 - 19	
			QC 3 - 43	
			QC 3 - 24	
			QC 3 - 61	
			QC 3 - 81	
			QC 3 - 82	
210	Packaging 3-1 - Stock - B4B	8 pcs	0.00 0.00	Packaging 3 - 1 - B4B
				Packaging 3 - 2 - B4B
				Packaging 3 - 3 - B4B
				Packaging 3 - 4 - B4B
				Packaging 3 - 5 - B4B
				Packaging 3 - 6 - B4B
				Packaging 3 - 7 - B4B
				Packaging 3 - 8 - B4B
				Packaging 3 - 9 - B4B
				Packaging 3 - 10 - B4B
				Packaging 3 - 11 - B4B
				Packaging 3 - 12 - B4B
				Packaging 3 - 13 - B4B
				Packaging 3 - 14 - B4B
				Packaging 3 - 15 - B4B
				Packaging 3 - 16 - B4B
				Packaging 3 - 17 - B4B
				Packaging 3 - 18 - B4B
				Packaging 3 - 19 - B4B
				Packaging 3 - 20 - B4B
				Packaging 3 - 21 - B4B
				Packaging 3 - 22 - B4B
				Packaging 3 - 23 - B4B
				Packaging 3 - 24 - B4B
				Packaging 3 - 25 - B4B
				Packaging 3 - 26 - B4B
				Packaging 3 - 27 - B4B
				Packaging 3 - 28 - B4B
				Packaging 3 - 29 - B4B
				Packaging 3 - 30 - B4B
				Packaging 3 - 31 - B4B
				Packaging 3 - 32 - B4B
				Packaging 3 - 33 - B4B
				Packaging 3 - 34 - B4B
				Packaging 3 - 35 - B4B
				Packaging 3 - 36 - B4B
				Packaging 3 - 37 - B4B
220	QC 21 - SA	8	0.00 0.00	QC 21 - SA - 21

DAS
40
MAY 05 2020
9-89

DAS
72
9-89

DAS
21
MAY 07 2020
9-89

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pcs

QC 21 - SA - 70

QC 21 - SA - 53

Part Op **100** - (Weld per dwg A/R Aluminum rod Batch: 130137 1-Cut D2244 to 89.70" at 34 deg as per dwg D2563 2-Debur ends
 Descriptions: 3-Weld (1 END CAP, LUG PLATES & MOUNTING ANGLE) as per dwg D2563 using DT 8343 4- Grind
110 - (QC9- Inspect visual per QSI004- Fusion Welds)
120 - (QC5- Inspect part completeness to step on W/O)
130 - (Chemical Conversion Coat per QSI005 4.1)
140 - (QC7-Inspect Chemical Conversion Coat)
150 - (Weld per dwg A/R Aluminum rod Batch: _____) 1-Inspect for foreign object per QSI 024 2-Weld Remaining End cap
 as per Dwg D2563 using DT 8343 3-Grind
160 - (QC10- Inspect visual per QSI004- ground welds)
170 - (QC5- Inspect part completeness to step on W/O)
175 - (Pressure Wash per QSI005 4.3/ Clean and remove all markings) Touch up Alodine as per QSI005
180 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum) Touch up Alodine then Powder Coat White Gloss (Ref: 4.3.5.1) as
 per QSI 005 4.3 START TIME: _____
190 - (Wing Walk as per dwg QSI005 4.4 Batch _____)
200 - (QC3- Inspect Part Finish)
210 - (Identify as per dwg & Stock Location: _____)
220 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2244-116	Step Extrusion	8 pcs (1 ea)	100-Large Fab - Welded Assy-1	5210457
D2561	Lug	16 pcs (2 ea)	100-Large Fab - Welded Assy-1	5245356
D2564	Mounting Angle	16 pcs (2 ea)	100-Large Fab - Welded Assy-1	5251096
D2673-34	End Plate	8 pcs (1 ea)	100-Large Fab - Welded Assy-1	5231911/5267734x2
D2673-34	End Plate	8 pcs (1 ea)	150-Large Fab - Welded Assy-2- B4B	5267734x8

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Large Fab - Welded Assy-1	D2244-116	8	64	0
	D2561	16	24	0
	D2564	16	19	0
	D2673-34	8	6	0
	D2673-34	8	6	0
150-Large Fab - Welded Assy-2- B4B	D2673-34	8	6	0

Part Specifications

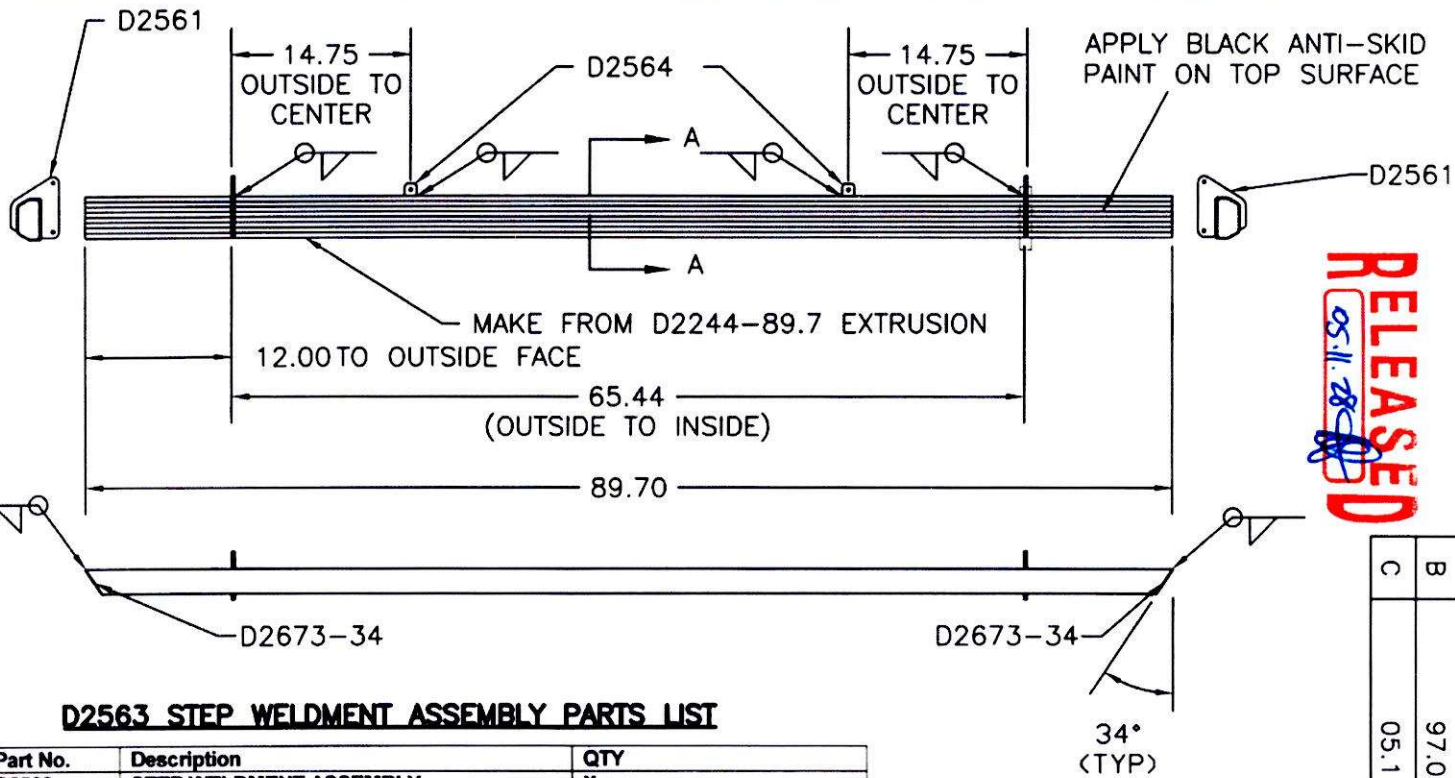
Specifications could not be found.

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RELEASED
05.11.28

DESIGN	BW	DRAWN BY	44	DART AEROSPACE LTD
CHECKED	44	APPROVED	44	HAWKESBURY, ONTARIO, CANADA
DATE	05.11.14	TITLE	D2563	REV. C
			STEP WELDMENT ASSEMBLY	SHEET 1 OF 1
				SCALE 1:15
A	96.04.26	NEW ISSUE		
B	97.05.14	END CAPS CHANGED (WAS D2248)		
C	05.11.14	UPDATE NOTES		



D2563 STEP WELDMENT ASSEMBLY PARTS LIST

Part No.	Description	QTY
D2563	STEP WELDMENT ASSEMBLY	X
D2244-89.7	EXTRUSION*	1
D2561	LUG PLATE	2
D2564	MOUNTING ANGLE	2

*cut per drawing

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 208025

D2563 STEP WELDMENT ASSEMBLY NOTES

- 1) MAKE FROM EXTRUSION D2244
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
MASK OFF 0.50 ON EACH SIDE OF D2561 LUGS BEFORE
APPLYING BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier Quality ☐		
Date :	Sequence #:	QTY Affected :		MRB (QS1042)
Description Work Order Deviation		Disposition		Completed By
				Lead hand / Supervisor
				QC / QA Coordinator
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐	FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:				